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UNITED STATES DEPARTMENT OF AGRICULTURE



Consumer Protection Programs

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PROCUREMENT SECTION
CURRENT SERIAL RECORDS

Program Issuances For The Period

10/18/70 - 10/31/70

Publication Number 70-21



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UNITED STATES DEPARTMENT OF AGRICULTURE

Darrow DU 8-3285
McDavid DU 8-4026

Washington, Oct. 15, 1970

USDA Tests Show Cooked Sausages in Compliance with Fat Limit:

The U.S. Department of Agriculture announced today that laboratory reports received in Washington during the third quarter of 1970 show that 97.8 percent of cooked sausage samples were in compliance with the procedural requirements for fat content. This is up from 96.4 percent during the second quarter; and 96.1 percent during the first quarter.

These tests were made as part of the Federal meat inspection program's continual check on plant production procedures and inspection controls over the composition of cooked sausages, such as frankfurters and bologna. A 30 percent fat limit in these products became effective in October, 1969.

Officials of USDA's Consumer and Marketing Service said the average fat content of the July-September samples tested specifically for fat was 27.9 percent, up slightly from the 27.2 percent during the second quarter and down from the 28.5 percent level for the January-March quarter.

4260

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USDA 3214-70

Out of the 5,270 samples reported in the third quarter, 90.2 percent contained 30 percent fat or less, 7.6 percent ranged from 30.1 through 31.6 percent fat, and 2.2 percent contained 31.7 percent fat or more. During the second quarter of 1970 tests showed 89.1 percent of the samples at or below 30 percent fat, 8.5 percent ranged from 30.1 to 31.6 percent fat and 2.4 percent of the samples contained 31.7 percent or more fat.

A statistical survey showed that in sampling, an allowance of 1.6 percent fat above the 30 percent limit is necessary because of analytical and sample variances within a lot of the product.

Of the total number of samples, 3,366 were tested specifically for fat content. Screening tests on the remaining 1,904 samples showed their fat content was 30 percent or less, although the exact percentages of fat was not determined.

Varying degrees of corrective action are required when samples within a lot of product test from 30.1 through 31.6 percent fat. When lots are out of compliance, testing is intensified and shipments are halted until test results are in compliance.

Officials said listing sheets, showing the fat content of each sample tested and reported by USDA laboratories during the third quarter of 1970, together with the name and location of the manufacturers, will be available in early November.

USDA 3214-70

UNITED STATES DEPARTMENT OF AGRICULTURE

LoCastro DU 8-3285
McDavid DU 8-4026

Washington, Oct. 19, 1970

USDA Certifies Missouri's Poultry Inspection Equal to Federal:

The U.S. Department of Agriculture today certified the Missouri poultry inspection program equal to the Federal one, under provisions of the Wholesome Poultry Products Act.

As a result, Missouri now has full responsibility for inspection of poultry slaughter and processing plants doing business wholly within the state. Twenty-three intrastate plants now operating there will be affected by the certification.

To earn "at least equal to" status, Missouri had to develop a law and regulations, financing and staffing, as well as actual inspection, matching the Federal program conducted by USDA's Consumer and Marketing Service.

Half of Missouri's budget for poultry inspection comes from Federal matching funds supplied by C&MS.

Missouri joins three other states in having "at least equal to" poultry inspection status: California, New Mexico and South Carolina. These three states were certified in July.

4290

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USDA 3249-70

UNITED STATES DEPARTMENT OF AGRICULTURE

LoCastro DU 8-3285
McDavid DU 8-4026

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Washington, Oct. 19, 1970

Federal Meat Inspection Suspended at Ohio Plant:

The U.S. Department of Agriculture announced today that Federal meat inspection has been suspended at Capital City Products Company, Division of Stokely-Van Camp, Inc., 525 West First Avenue, Columbus, Ohio, effective Oct. 16.

USDA's Consumer and Marketing Service said that sanitation in the plant did not meet Federal requirements.

Officials said the plant is not entitled to process meat or meat products for interstate shipment, or to use the Federal inspection mark while the suspension is in effect. Ohio State officials were advised of the suspension.

C&MS officials said inspection was withheld from this plant in June, 1969, for conditions similar to those found in the Oct. 16 review.

Inspection service was suspended at the Capital City plant under provisions of the Federal Meat Inspection Act and the regulations issued under it. They require that all meat and meat products shipped in interstate or foreign commerce pass inspection before and after slaughter, and that plants and facilities be operated under sanitary conditions.

UNITED STATES DEPARTMENT OF AGRICULTURE

LoCastro DU 8-3285
McDavid DU 8-4026

Washington, Oct. 27, 1970

USDA Certifies Idaho's Meat Inspection Equal to Federal:

The U.S. Department of Agriculture today certified the Idaho meat inspection program equal to the Federal one, under provisions of the Wholesome Meat Act.

As a result, Idaho now has full responsibility for inspection of meat slaughter and processing plants doing business wholly within the state. Fifty-five intrastate plants now operating there will be affected by the certification.

To earn "at least equal to" status, Idaho had to develop a law and regulations, financing and staffing, as well as actual inspection, matching the Federal program conducted by USDA's Consumer and Marketing Service.

Half of Idaho's budget for meat inspection comes from Federal matching funds supplied by C&MS.

Idaho joins four other states in having "at least equal to" meat inspection status: California, Florida, Maryland and New Mexico.

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4352

USDA 3324-70

UNITED STATES DEPARTMENT OF AGRICULTURE

LoCastro DU 8-3285
McDavid DU 8-4026

Washington, Oct. 28, 1970

USDA Certifies Tennessee's Meat Inspection Equal to Federal:

The U.S. Department of Agriculture today certified the Tennessee meat inspection program equal to the Federal one, under provisions of the Wholesome Meat Act.

As a result, Tennessee now has full responsibility for inspection of meat slaughter and processing plants doing business wholly within the State. The certification will affect 247 intrastate plants now operating there.

To earn "at least equal to" status, Tennessee had to develop a law and regulations, financing and staffing, as well as actual inspection, matching the Federal program conducted by USDA's Consumer and Marketing Service.

Half of Tennessee's budget for meat inspection comes from Federal matching funds supplied by C&MS.

Tennessee joins 6 other States in having "at least equal to" meat inspection status: California, Florida, Idaho, Maryland, New Mexico and Washington.

4367

USDA 3346-70

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UNITED STATES DEPARTMENT OF AGRICULTURE

LoCastro DU 8-3285
McDavid DU 8-4026

Washington, Oct. 28, 1970

USDA Certifies Washington's Meat Inspection Equal to Federal:

The U. S. Department of Agriculture today certified the Washington meat inspection program equal to the Federal one, under provisions of the Wholesome Meat Act.

As a result, Washington now has full responsibility for inspection of meat slaughter and processing plants doing business wholly within the state. Thirty-nine intrastate plants now operating there will be affected by the certification.

To earn "at least equal to" status, Washington had to develop a law and regulations, financing and staffing, as well as actual inspection, matching the Federal program conducted by USDA's Consumer and Marketing Service.

Half of Washington's budget for meat inspection comes from Federal matching funds supplied by C&MS.

Washington joins five other states in having "at least equal to" meat inspection status: California, Florida, Maryland, New Mexico, and Idaho.

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4368

USDA 3347-70

UNITED STATES DEPARTMENT OF AGRICULTURE

CONSUMER AND MARKETING SERVICE

WASHINGTON, D.C. 20250

Title 7—AGRICULTURE**Chapter I—Consumer and Marketing Service (Standards, Inspections, Marketing Practices), Department of Agriculture****SUBCHAPTER D—REGULATIONS UNDER THE POULTRY PRODUCTS INSPECTION ACT****PART 81—INSPECTION OF POULTRY AND POULTRY PRODUCTS****Moisture Absorption and Retention Restrictions for Poultry**

On March 20, 1970, there was published in the *FEDERAL REGISTER* (35 F.R. 4865) a notice of a proposed amendment to § 81.50 of the regulations Governing the Inspection of Poultry and Poultry Products (7 CFR, Part 81). The amendment was proposed to provide for the use of testing methods to determine moisture absorption in poultry so as to assure compliance with moisture limitations, and further to update present moisture tolerances for turkeys.

Statement of Considerations. The Consumer and Marketing Service of the Department of Agriculture is responsible for administering the Poultry Products Inspection Act so as to assure that poultry products prepared under inspection pursuant to the Act are fit for human food and not adulterated. This responsibility requires that studies of inspection procedures and requirements be conducted periodically to determine if this objective is being met and the consumer is receiving adequate protection.

In order to prevent incubation and rapid growth of bacteria on or within poultry carcasses, body heat should be promptly removed from slaughtered poultry. Most food poisoning bacteria have not been reported capable of growth at temperatures below 40° F. Thus, chilling requirements are designed to reduce the internal temperature of poultry to 40° F. or lower to preclude growth of food poisoning bacteria. This is accomplished through washing and immediate chilling of the carcasses. During these stages, some moisture absorption is inevitable. Realizing the need for controls, the Department collected a substantial amount of data and established limits based on absorbed water that was deemed unavoidable. Moisture control in poultry is designed to allow the processor to deep chill, preserve wholesomeness, and extend

shelf life of the product. All moisture absorbed above the allowed limits is unnecessary and, therefore, considered adulteration. As chilling equipment and techniques become more mechanized, and with more flexibility desired by industry, changes in control methods are necessary to reduce the possibility that poultry may contain excessive amounts of moisture.

Present moisture limitations are administered by Federal moisture controllers responsible for establishing systems of washing, chilling, and draining in each plant. These systems cannot be changed without prior approval and a return visit by a moisture controller. Corrective action is based on the controller's tests and the resident inspectors' surveillance of the established system. This method does not provide flexibility in chilling systems, nor does it take into consideration differences of individual lots of poultry.

This amendment provides acceptance and rejection criteria to assure that the amount of moisture absorbed or retained in poultry does not exceed maximum limitations. It also permits more flexibility to the poultry processor for adjusting chilling systems as long as the maximum moisture limits are not exceeded. Periodic testing and timely retention of all products that are not found to comply with maximum limitations will strengthen the present program and reduce the probability of poultry adulterated with excess water reaching the consumer.

As the result of the publication in the *FEDERAL REGISTER* of the notice of proposed amendment to § 81.50 of the regulations, the Department received 69 letters of comment from consumers, members of the poultry industry, and consumer and industry groups. The Department has carefully considered all of the information presented in these comments and all other available information. Based on such information, several changes have been made in the proposed amendment that was published in the *FEDERAL REGISTER* on March 20, 1970.

The primary difference in this amendment and the previous publication is the provision for zones of moisture absorption limitations to determine compliance. This statistical concept is necessary due to the large number of poultry carcasses that will be represented by the sample. These zones will serve inspectors and plants as a warning device when pro-

cedures are producing birds that approach the upper limits. This will enable the plant to adjust chilling procedures downward to avoid retention of product or, in many cases, a complete halt of operations.

The statistical sampling plan will adequately provide the desired consumer protection. However, it should be understood that in order for plants consistently to remain under the moisture absorption limits, the overall average absorption must be well below the maximum limitations. The percentage below the limits will vary from plant to plant depending on the efficiency of the individual operation.

Another change from the original proposed regulation is the addition of subparagraph (3)(viii) that will require plants to provide scales, weights, identification devices, and other supplies necessary to conduct all moisture tests. Each plant must have such equipment, devices, and supplies to conduct tests in order to adjust its chilling system when necessary, and the inspectors will need such equipment, devices, and supplies to conduct their daily tests for compliance purposes in accordance with these amended regulations.

The specific amendment to the regulations is as follows:

Subparagraphs (3)(ii), (3)(iii), and (3)(iv), paragraph (b) of § 81.50, are revoked, subparagraph (3)(v) is renumbered as subparagraph (3)(ix), and new subparagraphs (3)(ii), (3)(iii), (3)(iv), (3)(v), (3)(vi), (3)(vii), and (3)(viii) are added to read as follows:

§ 81.50 Temperatures and cooling and freezing procedures.

* * * * *

(b) * * *

(3) * * *

(ii) Poultry washing, chilling, and draining practices and procedures shall be such as will minimize moisture absorption and retention at time of packaging. With respect to ready-to-cook poultry that is to be consumer packaged, frozen or cooked, the maximum moisture absorption and retention during washing, chilling, and draining processes shall not exceed, at the last readily accessible point at which the poultry carcasses can be selected for testing prior to packaging, the percentage limits set forth in the following tables:

TABLE 1.—MAXIMUM LIMITS FOR ALL CLASSES OF POULTRY, OTHER THAN TURKEYS, TO BE CONSUMER PACKAGED, FROZEN OR COOKED.

Average ready-to-cook carcass weight prior to final washer (less necks and giblets)

Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)

Zone A product shall be retained if more than one test exceeds	Zone B product shall be retained if any test exceeds
---	--

Chickens over 4½ lbs. and under -----	8.0	8.7
Chickens over 4½ lbs. and all other classes of poultry other than turkeys -----	-----	-----
turkeys -----	6.0	6.7

TABLE 2—MAXIMUM LIMITS FOR ALL TURKEYS TO BE CONSUMER PACKAGED, FROZEN OR COOKED

Average ready-to-cook carcass weight prior to final washer (less necks and giblets)	Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)	
	Zone A product shall be retained if more than one test exceeds these limits	Zone B product shall be retained if any test exceeds these limits
Less than 8 lbs. 8 ozs. -----	8.0	9.0
8 lbs. 9 ozs.-15 lbs. 15 ozs. -----	6.0	6.4
16 lbs.-16 lbs. 15 ozs. -----	5.8	6.05
17 lbs.-17 lbs. 15 ozs. -----	5.5	5.75
18 lbs.-18 lbs. 15 ozs. -----	5.3	5.55
19 lbs.-19 lbs. 15 ozs. -----	5.1	5.35
20 lbs.-20 lbs. 15 ozs. -----	4.9	5.15
21 lbs.-21 lbs. 15 ozs. -----	4.8	5.05
22 lbs.-22 lbs. 15 ozs. -----	4.6	4.85
23 lbs.-23 lbs. 15 ozs. -----	4.5	4.75
24 lbs.-26 lbs. 15 ozs. -----	4.4	4.65
27 lbs. and over -----	4.3	4.55

(iii) With respect to ready-to-cook turkey carcasses that are to be cut up, the maximum amount of moisture absorption and retention shall not exceed (at the time the first cut is made) the percentage limits set forth in the following table:

MAXIMUM LIMITS FOR ALL TURKEYS TO BE CUT-UP

Average ready-to-cook carcass weight prior to final washer (less necks and giblets)	Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)	
	Zone A product shall be retained if more than one test exceeds these limits	Zone B product shall be retained if any test exceeds these limits
Less than 8 lbs. 8 ozs. -----	9.0	10.0
8 lbs. 9 ozs.-15 lbs. 15 ozs. -----	7.0	7.4
16 lbs.-16 lbs. 15 ozs. -----	6.8	7.5
17 lbs.-17 lbs. 15 ozs. -----	6.5	6.75
18 lbs.-18 lbs. 15 ozs. -----	6.3	6.65
19 lbs.-19 lbs. 15 ozs. -----	6.1	6.35
20 lbs.-20 lbs. 15 ozs. -----	5.9	6.15
21 lbs.-21 lbs. 15 ozs. -----	5.8	6.05
22 lbs.-22 lbs. 15 ozs. -----	5.6	5.85
23 lbs.-23 lbs. 15 ozs. -----	5.5	5.75
24 lbs.-26 lbs. 15 ozs. -----	5.4	5.65
27 lbs. and over -----	5.3	5.55

(iv) With respect to ready-to-cook chicken carcasses, averaging 4½ pounds or less, that are chilled in continuous chillers and further aged or chilled in slush ice and water prior to being cut up, the maximum amount of moisture absorption and retention shall not exceed (when placed on the cutup line) the percentage limits set forth in the following table:

AVERAGE PERCENT INCREASE IN WEIGHT OVER WEIGHT OF CARCASS PRIOR TO FINAL WASHER (LESS NECKS AND GIBLETS)

CFR AMENDMENT 70-30

Zone A—Product shall be retained if more than one test exceeds-----	10.0
Zone B—Product shall be retained if any test exceeds-----	11.0

With respect to ready-to-cook chicken carcasses, averaging $4\frac{1}{4}$ pounds or less, which are chilled in continuous chillers only prior to being cut up, the percentage limits set forth in § 81.50(b)(3)(v) shall apply.

(v) With respect to ready-to-cook poultry that is to be ice packed, the maximum amount of moisture absorption shall not exceed, at the last readily accessible point at which the poultry carcasses can be selected for testing on the drip line, the percentage limits set forth in the following table:

MAXIMUM LIMITS FOR ICE PACK POULTRY	
AVERAGE PERCENT INCREASE IN WEIGHT OVER WEIGHT OF CARCASS PRIOR TO FINAL WASHER (LESS NECKS AND GIBLETS)	

Zone A—Product shall be retained if more than one test exceeds-----	12.0
Zone B—Product shall be retained if any test exceeds-----	13.0

With respect to all ice pack poultry, the loss of moisture during holding and transportation to the first destination shall result in moisture retention that is within the limits, applicable to the class of poultry involved, set forth in Zone A of Tables 1 and 2 in § 81.50(b)(3)(ii).

(vi) Each official establishment may make adjustments in its washing, chilling, and draining methods provided it submits to the inspector at the establishment written notice of the proposed adjustments before any changes are made, and provided further, that the establishment, immediately after the change, selects, prepares, identifies, and weighs, in accordance with procedures set forth in the Poultry Inspectors' Handbook,¹ individually a random sample of 50 ready-to-cook poultry carcasses prior to the final washer and again when they are removed from the drip line or other draining device immediately before packing. If the average weight of the 50 poultry carcasses taken before the final washer and their average weight after immediate removal from the drip line or draining device show that the product is in compliance with the Zone A moisture absorption limits, applicable to the class of poultry involved, set forth in this section, the adjustments will become the established washing, chilling, and draining system for the establishment.

If the results of the weighing of the sample of 50 carcasses show that the product exceeds the Zone A limits set forth in this section, the poultry will be retained in accordance with procedures set forth in the Poultry Inspectors' Handbook. Retained poultry shall not be released from the establishment until com-

pliance is attained by following procedures set forth in subparagraph (3)(vii) of this section.

(vii) Ten-bird tests shall be conducted at least daily by inspectors to assure compliance with the requirements of this section using procedures set forth in the Poultry Inspectors' Handbook; the inspectors' 10-bird test will be used to determine compliance. If the average weights of tested poultry from an official establishment show that they exceed the moisture absorption limits set forth in this section, all poultry of the class of poultry tested which is processed through the chilling system at that establishment after the test results were obtained, shall be retained by the inspector at the establishment, in accordance with a method approved by the Administrator, until a subsequent test shows that such poultry being processed at the establishment is in compliance with this section. Retained poultry shall not be released from the establishment until it is brought into compliance with the limits, applicable to the class of poultry retained, set forth in Zone A of Tables 1 and 2 of § 81.50(b)(3)(ii), by a method approved by the Administrator.

(viii) The establishment shall provide scales, weights, identification devices, and other supplies necessary to conduct all moisture tests.

(ix) The temperature of the chilling media in poultry chilling equipment shall not exceed 65° F. in the warmest part of the chilling system.

* * * * *

(Sec. 14, 82 Stat. 791, as amended, 21 U.S.C. 463; 29 F.R. 16210, as amended; 33 F.R. 10750)

The foregoing amendment differs in a number of respects from the proposal set forth in the notice of rulemaking. The differences are due to changes made pursuant to comments received in the rulemaking proceeding. It does not appear that further public rulemaking procedure on the amendment would make additional information available to the Department. Therefore, under the administrative procedure provisions in 5 U.S.C. 553, it is found upon good cause that such further proceedings are unnecessary. The foregoing amendment shall become effective on January 4, 1971.

Done at Washington, D.C., on: September 30, 1970.

G. R. GRANGE,
Acting Administrator.

[F.R. Doc. 70-13294; Filed, Oct. 6, 1970;
8:45 a.m.]

¹ The Poultry Inspectors' Handbook is available upon request from the Consumer and Marketing Service of this Department.

UNITED STATES DEPARTMENT OF AGRICULTURE
CONSUMER AND MARKETING SERVICE

WASHINGTON, D.C. 20250

Title 7—AGRICULTURE**Chapter I—Consumer and Marketing Service (Standards, Inspections, Marketing Practices), Department of Agriculture****SUBCHAPTER D—REGULATIONS UNDER THE POULTRY PRODUCTS INSPECTION ACT****PART 81—INSPECTION OF POULTRY AND POULTRY PRODUCTS****Moisture Absorption and Retention Restrictions for Poultry****Correction**

In F.R. Doc. 70-13294 appearing at page 15739 in the issue of Wednesday, October 7, 1970, the following changes should be made in § 81.50(b)(3):

1. In subdivision (ii) the entry in the first column of Table 1 reading "Chickens over 4 1/4 lbs. and under" should read "Chickens 4 1/4 lbs. and under".

2. Tables 1 and 2 in subdivision (ii) and in the table in subdivision (iii), in the headings for the second and third columns the word "product" following the words "Zone A" or "Zone B" should be capitalized in each instance.

PART 81—INSPECTION OF POULTRY AND POULTRY PRODUCTS**Moisture Absorption and Retention Restrictions for Poultry**

On October 7, 1970, there was published in the FEDERAL REGISTER (35 F.R. 15739-15741, F.R. Doc. 70-13294) an amendment to § 81.50 of the Federal poultry product inspection regulations (7 CFR 81.50) providing for the use of testing methods to determine moisture absorption in poultry so as to assure compliance with moisture limitations, and further to update present moisture tolerances for turkeys. In the table in amended § 81.50(b)(3)(iii) there is an error under Zone B in that "7.5" should be "7.05." The table is hereby corrected to read as follows:

MAXIMUM LIMITS FOR ALL TURKEYS TO BE CUT-UP

Average ready-to-cook carcass weight prior to final washer (less necks and giblets)	Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)	Zone A	Zone B
Product shall be retained if more than one test exceeds these limits	Product shall be retained if any test exceeds these limits		
Less than 8 lbs. 8 ozs-----	9.0	10.0	
8 lbs. 9 ozs.-15 lbs. 15 ozs-----	7.0	7.4	
16 lbs.-16 lbs. 15 ozs-----	6.8	7.05	
17 lbs.-17 lbs. 15 ozs-----	6.5	6.75	
18 lbs.-18 lbs. 15 ozs-----	6.3	6.55	
19 lbs.-19 lbs. 15 ozs-----	6.1	6.35	
20 lbs.-20 lbs. 15 ozs-----	5.9	6.15	
21 lbs.-21 lbs. 15 ozs-----	5.8	6.05	
22 lbs.-22 lbs. 15 ozs-----	5.6	5.85	
23 lbs.-23 lbs. 15 ozs-----	5.5	5.75	
24 lbs.-26 lbs. 15 ozs-----	5.4	5.65	
27 lbs. and over-----	5.3	5.55	

(Sec. 14, 71 Stat. 447, as amended, 82 Stat. 803, 21 U.S.C. 463; 29 F.R. 16210, as amended; 33 F.R. 10750)

The chart set forth in the regulations published on October 7, 1970, inadvertently specified 7.5 as the maximum average percentage of increase in weight permitted in turkey carcasses over the weight of the carcasses prior to the final washing. The percentage should have been 7.05, and the necessary correction is made by the foregoing amendment in the light of comments made with respect to the notice of rulemaking (35 F.R. 4865) which was published before said regulations were adopted.

It does not appear that publication of a notice of rulemaking or public participation in connection with correction of this percentage in the regulations would make additional information available to the Department. Therefore, under the administrative procedures provisions in 5 U.S.C. 553, it is found upon good cause that such further rulemaking procedures are impracticable and unnecessary.

This amendment shall become effective on January 4, 1971.

Done at Washington, D.C., on October 23, 1970.

KENNETH M. McENROE,
Deputy Administrator,
Consumer Protection.

[F.R. Doc. 70-14494; Filed, Oct. 27, 1970;
8:48 a.m.]

ACTION BY: Regional Directors and Program Directors
Budget and Finance Division
State Agencies

Procedure for Handling Charges
Involving Cooperative Agreements

I PURPOSE

This Notice is to establish an interim procedure for handling charges between the Federal and State Governments under certain cooperative agreements. It will be made a part of C&MS Instruction 910-2, Procedures for State Government Agencies Participating in Federal-State Cooperative Meat and Poultry Inspection Programs.

II EFFECTIVE DATE

These procedures are effective November 1, 1970.

III TYPE OF AGREEMENTS

Certain agreements with State agencies have now been put into effect that provide "the services of the Program Director under this agreement with respect to the State inspection program will constitute a part of the Federal financial assistance to the State agency for administration of the State programs." This language intended that the costs of the Program Director when working on the State program be considered a part of the total costs of the State program. It shall be used in determining the value of Federal financial assistance. Under these agreements, the Program Director is in charge of the Federal program as well as working on the State program.

IV DETERMINATION OF CHARGES TO STATE

The State shall be charged for the time the Program Director is actually working on the State program. Similarly, if the State provides the Program Director with such services as an automobile, secretary, office space, etc.,

the State may be given full reimbursement for that portion of these costs while they are being used on the Federal program.

V BASIS FOR BILLING

The following action shall be taken to execute a billing to the State for the Program Director's services:

A The Program Director shall prepare a Form C&MS-488, Services Rendered, monthly reflecting the number of hours worked on the State program. Submit this to the Regional Office at the close of each month.

B The Regional Office shall transmit the C&MS-488 to the Budget and Finance Division in Hyattsville, Maryland, by Form C&MS-541, Statement of Charges, indicating the charges for salary, benefits, and travel expenses, if any, for the employee involved.

C The Budget and Finance Division shall bill the State agency in the normal billing procedure.

VI EFFECT ON STATE COSTS

A Charges for Use of State Facilities: State agencies may send their billing for such charges to the Regional Office. These are for full reimbursement and should not be included in the cost report. The Regional Office should approve these, if proper and reasonable, and send them to the Budget and Finance Division for payment.

B Charges Billed to State Agencies: Such charges to the State agency for the services of the Program Director may be included in the State's monthly cost report.



Kenneth M. McEnroe
Deputy Administrator
Consumer Protection Programs



UNITED STATES DEPARTMENT OF AGRICULTURE
Consumer and Marketing Service
Washington, D. C. 20250

C&MS NOTICE 1188

ACTION BY: All C&MS Timekeepers

INFORMATION FOR: All Divisions and Offices

Time and Attendance Reporting Procedures

Management Data Service Center Instructions.

The Management Data Service Center (MDSC) issued a memorandum on September 25, 1970, on the subject of "Implementation of the Environmental Differential Pay, Related Revision of Time and Attendance Reports, and Other Time and Attendance Report Revisions." This memorandum was sent to all T&A Contact Points and Accounting Stations. It required the use of revised T&A Report forms and procedures. The instructions given in the MDSC memorandum for use of revised T&A Report forms are to be disregarded by C&MS timekeepers.

Action BY C&MS Timekeepers.

C&MS timekeepers shall:

A Continue to use the T&A Report Forms AD-318 and AD-324 dated 11-13-62. The revised Forms AD-318 and AD-324 dated 9-70 will not be used because:

1 C&MS has no Wage Board employees who are eligible for the new environmental differential pay; and

2 Work is almost completed on a new T&A Report form for C&MS and an interim change to the forms revised 9-70 would create unnecessary confusion.

B Make the following changes in present reporting procedures effective with T&A reports for pay period 22 (11/1-11/14/70):

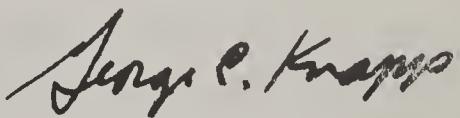
1 Use Transaction Code 73 to report periods of suspension. If an employee is suspended, report this absence on the T&A Report by crossing out either Transaction Code 71 (LWOP) or 72 (AWOL) and entering in its place Transaction Code 73 (SUSP). Add any hours recorded under Transaction Code 73 to the total leave without pay for the year for leave accrual reduction purposes.

DISTRIBUTION:
A,M,O,S,S16-1,S17
(All C&MS Timekeepers)

Page 1
October 21, 1970

2 Use Transaction Code 65 to report time absent on regular military leave for training. There are no other changes in reporting and accumulating the days chargeable up to the 15 calendar-day limit.

3 Use Transaction Code 79 to report emergency military leave. Enter Transaction Code 79 and the cumulative total hours of emergency military leave in the "Remarks" block until the new T&A Report form for C&MS with a preprinted line for this Transaction Code is prescribed for use. The rules for charging hours, up to the 178-hour limit, are unchanged.



George C. Knapp
Deputy Administrator, Management



UNITED STATES DEPARTMENT OF AGRICULTURE
Consumer and Marketing Service
Consumer Protection Programs
Washington, D. C. 20250

POULTRY INSPECTORS' HANDBOOK

CHANGE: 21

October 31, 1970

PAGE CONTROL CHART

Remove Page	Dated	Insert Page	Dated
13, 14 and 14a	June 1968	13	June 1968
15 through 21	Undated	14 through 20	10-31-70
21a	9-5-70	21	Undated
		21a	9-5-70
75 and 76	Undated	75 and 76	10-31-70

The inspector-in-charge must see that the approved method of determining the amount of ice added is accurately followed.

With respect to continuous giblet chillers that chill giblets in direct contact with ice and water or refrigerated water, the amount of water required to be added to the chiller shall not be less than one gallon for every 40 birds processed, and a water meter shall be provided on the water inlet line. The temperature of the chilling media in this type of unit shall not exceed 36° F.

A daily record must be kept of the consumption of water in continuous poultry chillers and when applicable, giblet chillers. Form PY-36 is to be used to record this information.

FORM PY-36 (5-1-68)		USDA - C&MS POULTRY DIVISION	DATE	SIGNATURE OF INSPECTOR	
WATER AND TEMPERATURE CHECKS		CLASS(ES) OF POULTRY PROCESSED: (Check) <input type="checkbox"/> CHICKENS <input type="checkbox"/> TURKEYS <input type="checkbox"/> OTHER (specify)			
INSTRUCTIONS: The inspector-in-charge will prepare this report daily for each continuous carcass and giblet chiller. Staple completed report to corresponding recording thermometer chart before filing.					
TEMPERATURE OF PARTS RESULTING FROM SALVAGE	TEMPERATURE OF BIRDS AT THE POINT OF CUT-UP		WATER METER INFORMATION CARCASS CHILLER TOTAL USED: _____ GAL. X 2 _____ GIBLET CHILLER TOTAL USED: _____ GAL. X 40 _____ NUMBER OF BIRDS PROCESSED: _____		
	WATER TEMPERATURE CHECKS			CHILLED PRODUCT TEMPERATURES	
	RECORDING CHART TIME	RECORDING THERMOMETER TEMPERATURE	POCKET THERMOMETER TEMPERATURE	CARCASS	GIBLET

(USE REVERSE FOR INDIVIDUAL METER READINGS)

Also record TEMPERATURE CHECKS made periodically with hand thermometer of carcasses, giblets, and chilling media.

Use of Hand Thermometers

When taking temperatures of product (fresh or frozen), the warmest reading that can be found is to be used to determine compliance.

For individual carcass and part checks, the thermometer should be inserted into the thickest portion of the muscle. For bulk-packaged product, the thermometer should be inserted as near to the center portion as possible.

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NOTE: (Upon approval of the procedure used for measuring ice), ice may be substituted for water at the rate of 8.5 lbs. ice per gallon of water.

Plants which use continuous chillers must stop the agitation, either mechanical or air, when the elevators or conveyors which remove the poultry from the units are turned off. In addition, poultry shall not be left in the FIRST OR PRECHILL SECTION during breaks which are in excess of 15 minutes, unless the temperature of the chill media in this unit is lowered to and maintained at 40° Fahrenheit or below. If agitation is continued during period when the elevators or conveyors are stopped, the moisture absorption problem is aggravated. Furthermore, the procedure would not comply with the chilling systems established by plant management in conjunction with the moisture control teams.

All newly installed continuous chillers must be properly equipped with suitable recording thermometers and water meters before they may be used for chilling poultry.

As a safety measure, water meters and recording thermometers shall be so conveniently located as to eliminate the use of ladders, crawling on or under equipment, etc. When removed for repair or replacement, substitute units shall be installed. If in an emergency the plant is not equipped with substitute recording thermometers, a record shall be made by other means. This may be accomplished by a competent plant employee checking temperatures and recording readings on a chart at regular and frequent intervals. To insure that readings are correct even though the recording thermometers are working, the inspector in charge, by use of hand thermometers, shall periodically check the temperature of the chillers.

MOISTURE ABSORPTION OF POULTRY

General

*-Section 81.50 of the Regulations establishes definite moisture limits for ready-to-cook poultry. These limits specify the maximum amount of moisture which may be absorbed by poultry during the washing and chilling operations. The absorption of moisture in excess of the percentage limits set forth in this section is considered unnecessary and constitutes adulteration as defined in the Poultry Products Inspection Act. It is the responsibility of inspectors in charge to assure themselves that product is not adulterated. It is the responsibility of plant management to establish systems of washing, chilling, and draining which will consistently result in poultry not gaining moisture in excess of the permitted limits, and further it is the responsibility of the establishment to provide scales, weights, identification devices and other supplies necessary to conduct all moisture tests.

Moisture Control Sampling Methods

The following prescribes procedures and requirements for moisture control sampling:

- A. Inspector's Responsibilities. The inspector shall:-*

*-1. Conduct at least, but not limited to, one 10-bird test daily on each chilling system in a plant unless otherwise approved by the Regional Director. This includes ice pack, cut-up, frozen, and/or consumer packaged if applicable.

2. Immediately upon completion of test, make all necessary computations, distribution of forms, and the required contacts with plant management concerning inspector's test results.

3. Maintain complete moisture control file including results of tests, changes in chilling procedures, and current approved procedure.

4. Make sure that established procedures of washing, chilling, and draining are not changed in any manner that could result in excessive moisture absorption and retention. To fulfill this responsibility, inspectors must spot check these procedures several times during the day. Important items of the procedure that must be carefully checked include final washers, chill time, temperatures, amount and length of agitation, draining time, and opening cuts.

5. Allow changes in chilling procedures provided instructions in Part B are followed.

6. Spot check the weighing and accuracy of management's 50-bird test when procedure changes are made. Retain all product found to exceed limitations on the basis of the 50-bird test.

7. When a change is made from the established chilling procedure, other than lowering the temperature of the chilling media or lengthening drain times, without prior approval, product on hand shall be retained and continuously drained for not less than 24 hours.

8. Use 10-bird tests to determine compliance. (Any test or tests exceeding percentages outlined in the appropriate table will necessitate retaining product.) All product must be retained after a test shows noncompliance until a subsequent test is conducted that shows compliance. All product retained between these two time periods must comply with Part E (Procedure for Retained Product) before it can be released.

Product retention shall be according to class of poultry. If the plant changed to a different class, this product would not be retained until test results show noncompliance.

EXAMPLE: A test completed (including computations) at 9 a.m. exceeds the allowed limit (appropriate table). All product must be retained from 9 a.m. until a subsequent test shows compliance. If another test completed at 11 a.m. shows noncompliance, retention of the product shall continue. However, if the 11 a.m. test shows compliance, product would be retained only from 9 a.m. to 11 a.m. To be specific, retention begins when results of a noncompliance test are completed, and ends when results of a test showing compliance are completed.-*

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*-9. Allow management to change the procedure any time product is retained.

EXAMPLE: Test completed at 9 a.m. exceeds the allowed limit (appropriate table) and management changed the procedure at 9:15 a.m. The inspector completes another test or management completes a 50-bird test at 11 a.m. and the test shows compliance. Product would be retained from 9 a.m. to 11 a.m. This procedure change would then become mandatory until management changes procedures by complying with Part B.

10. Retain all product from the time of noncompliance test when it is not feasible to conduct subsequent tests.

EXAMPLE: Poultry is chilled overnight or the plant had finished operating for the day and a subsequent test could not be made. The following day's production must also be retained until a test is completed and shows compliance. Poultry retained under these circumstances would be released after complying with Part E (Procedure for Retained Product).

EXAMPLE: Test on Monday exceeded the allowed limit (appropriate table) and was required to drain 4 hours in order to reduce the excess moisture back to the limit set forth in Zone A, Table 1 or 2 in Part D(1) of this section, whichever is applicable to the class of poultry tested. All poultry produced Tuesday would be retained and required to drain at least 4 hours until a test is conducted showing compliance or the need for a different retention procedure.

11. Supervise selecting and weighing test samples of retained product before and after draining in accordance with Part E (Procedure for Retained Product).

B. Flexibility of Chilling Procedures. Management shall be allowed to change from an established procedure providing they:

1. Notify the inspector in charge in writing of the desired change.

2. Complete Form CP-528 (furnished by the inspector) to include minimum and maximum requirements on all factors affecting moisture absorption.

3. Conduct a 50-bird test immediately after the change and furnish the inspector in charge with the results of this test as soon as it is completed.

4. Follow the newly established procedure until another change is made by following the provisions of 1, 2, and 3 above.

C. Procedure for Conducting Moisture Tests.

1. Select an individual bird on the eviscerating line prior to first washer. Use this bird as a starting point and count the next five birds on the line; remove the fifth bird and use for sampling (do not use-*

*-birds with cuts, tears, or missing parts as part of sample, yet birds do not have to be Grade "A"). Should the fifth bird not be suitable for sampling, select the following bird. Continue the above described procedure until a complete sample is drawn.

2. Remove neck on all birds. Neck skins should be cut, leaving approximately one-fourth of the neck skins intact if this is the way birds are packed. Turkeys and fowl may be weighed with complete neck skins if the plant so chooses.

3. Identify individual birds with numbered tags. The tags are to be weighed with the birds on both the initial and final weighing.

4. Weigh birds to the nearest fraction of an ounce and record weights. All classes other than turkeys must be weighed to the nearest one-eighth ounce or less. Turkeys may be weighed to the nearest whole ounce.

5. Rehang birds on eviscerating line and allow them to pass through the washing, chilling, and draining processes.

6. Remove birds at the end of drip line or last readily accessible point before packing (giblets shall not be included in either weighing).

7. Weigh all birds individually and record weights. Test birds must not be allowed extra drainage. To prevent an incomplete test due to birds lost during testing, if more than 10 birds are tagged, the first 10 weighed after the chilling cycle are to be used for the official records. Any test birds received after the first 10 shall be discarded and not recorded. If more than two birds are lost from a 10-bird sample, the test shall be discarded.

8. Remove identification tags and allow birds to proceed through the normal packing operation.

9. To figure percentage, subtract the total weight (prior to washing) in terms of ounces, from the total weight, in terms of ounces, at the time of packing. Divide the first weight (prior to washing) into the difference.

EXAMPLE: 741.90 ounces is the weight of birds after chilling.

670.67 ounces is the weight of birds before washing.

$$\begin{array}{r} 741.90 \\ - 670.67 \\ \hline 71.23 \end{array} \qquad \begin{array}{r} 10.62\% \\ 670.67 / 71.230000 \end{array}$$

10. In conducting these tests, test birds must pass through the normal operations of the plant. This will result in the test birds getting identical treatment with the other birds, such as being chilled in tanks completely full of poultry, instead of tanks containing only test birds, or drained longer than usual.-*

*-11. Form CP-549 is to be used to record the data and five tests may be recorded on a single form. The first and final individual bird weights shall be recorded in the upper or first half of each column and the chilling and draining procedures and other pertinent information described in the bottom half of the column. The percent gain shall be calculated and shown for each test in the bottom portion of the form. (See sample completed Form CP-549 on page 19. A conversion chart which will assist you in converting pounds to ounces so that percent gain can be calculated may be obtained from the Regional office.) Form CP-549 shall be filled out in duplicate and one copy sent to the Regional office weekly and one copy retained in the inspector's file. If plant does not freeze or consumer pack, a negative Form CP-549 shall so state. Instructions on front and back of CP-549 are self-explanatory and must be followed in detail.

12. In plants which have both inspection and grading services and in which there is a floor inspector, the test weighing may be performed jointly by the inspector in charge and the grader in charge. In plants which have grading service and no floor inspector, the grader shall assist the inspector by conducting the test weighing. He may use the assistance of plant personnel under his observation. In plants having only inspection service, the inspector in charge shall have the sole responsibility for the testing and, in order to avoid line stoppage, he may use the assistance of plant personnel under his observation. In all instances, the inspector in charge shall make the necessary computations, distribution of the forms, and the required contacts with plant management.

These tests shall be made in accordance with the procedure set forth herein and shall be made at irregular intervals. In plants which process several different classes of poultry, a different class shall be tested each day unless circumstances necessitate a continuation of testing the same class.

D. Control Tables and Compliance Factors. The following control tables are to be used to determine compliance based on a series of five consecutive tests. Of the five tests, one test shall be allowed to exceed the limit in Zone A without retaining product. Any test exceeding the limit in Zone B shall necessitate retaining product from the time of noncompliance until a test is completed showing compliance. In all cases, retained poultry must comply with Part E before being released.

The inspector shall begin a new series each time five tests are completed on a particular class of poultry or an individual chilling system. This new series of five tests shall be applied to the appropriate table to determine compliance. The only exception is when poultry is retained on test #5, then the new series would not be started until a test showing compliance with the limits set forth in Zone A of the appropriate table is attained.

1. With respect to ready-to-cook poultry that is to be consumer packaged, frozen or cooked, the maximum moisture absorption and retention during washing, chilling and draining processes shall not exceed, at the last readily accessible point at which the poultry carcasses can be selected for testing prior to packaging, the percentage limits set forth in the following tables:-*

*-

TABLE I

Maximum limits for all classes of poultry other than turkeys
to be consumer packaged, frozen or cooked.

Average ready-to-cook carcass weight prior to final washer (less necks and giblets)	Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)	
	Zone A Product shall be retained if more than one test exceeds	Zone B Product shall be retained if any test exceeds
Chickens $4\frac{1}{2}$ lbs. and under	8.0	8.7
Chickens over $4\frac{1}{2}$ lbs. and all other classes of poultry other than turkeys	6.0	6.7

-*

*-

TABLE II
Maximum limits for all turkeys to be consumer
packaged, frozen or cooked.

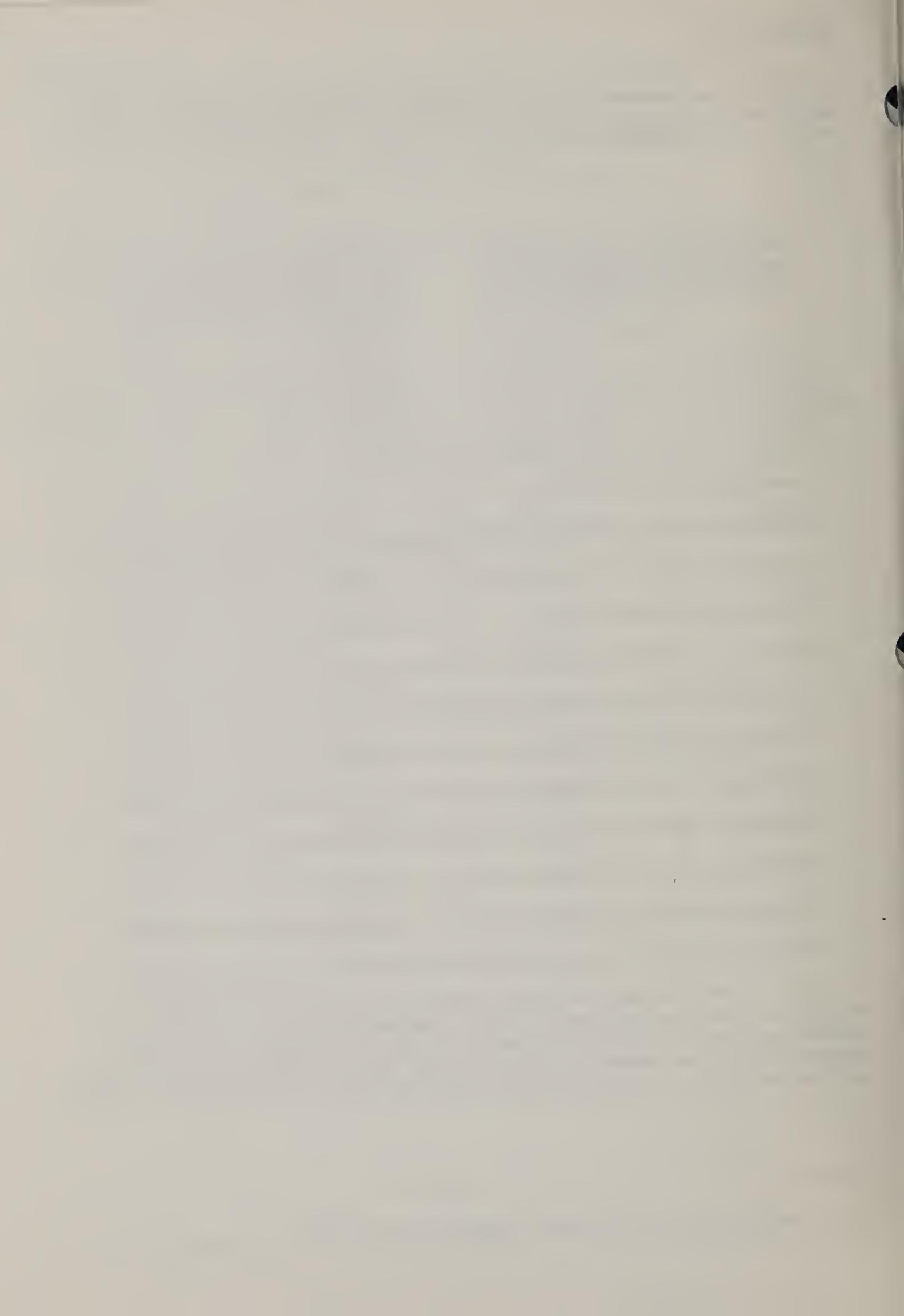
Average ready-to-cook carcass weight prior to final washer (less necks and giblets)	Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)	
	Zone A Product shall be retained if more than one test exceeds these limits	Zone B Product shall be retained if any test exceeds these limits
Less than 8 lbs. 8 ozs.	8.0	9.0
8 lbs. 9 ozs. - 15 lbs. 15 ozs.	6.0	6.4
16 lbs. - 16 lbs. 15 ozs.	5.8	6.05
17 lbs. - 17 lbs. 15 ozs.	5.5	5.75
18 lbs. - 18 lbs. 15 ozs.	5.3	5.55
19 lbs. - 19 lbs. 15 ozs.	5.1	5.35
20 lbs. - 20 lbs. 15 ozs.	4.9	5.15
21 lbs. - 21 lbs. 15 ozs.	4.8	5.05
22 lbs. - 22 lbs. 15 ozs.	4.6	4.85
23 lbs. - 23 lbs. 15 ozs.	4.5	4.75
24 lbs. - 26 lbs. 15 ozs.	4.4	4.65
27 lbs. and over	4.3	4.55

*- 2. With respect to ready-to-cook turkey carcasses that are to be cut-up, the maximum amount of moisture absorption and retention shall not exceed (at the time the first cut is made) the percentage limits set forth in the following table:

Maximum limits for all turkeys to be cut-up.

Average ready-to-cook carcass weight prior to final washer (less necks and giblets)	Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)	Zone A	Zone B
		Product shall be retained if more than one test exceeds these limits	Product shall be retained if any test exceeds these limits
<u>Less than 8 lbs. 8 ozs.</u>		9.0	10.0
<u>8 lbs. 9 ozs. - 15 lbs. 15 ozs.</u>		7.0	7.4
<u>16 lbs. - 16 lbs. 15 ozs.</u>		6.8	7.05
<u>17 lbs. - 17 lbs. 15 ozs.</u>		6.5	6.75
<u>18 lbs. - 18 lbs. 15 ozs.</u>		6.3	6.55
<u>19 lbs. - 19 lbs. 15 ozs.</u>		6.1	6.35
<u>20 lbs. - 20 lbs. 15 ozs.</u>		5.9	6.15
<u>21 lbs. - 21 lbs. 15 ozs.</u>		5.8	6.05
<u>22 lbs. - 22 lbs. 15 ozs.</u>		5.6	5.85
<u>23 lbs. - 23 lbs. 15 ozs.</u>		5.5	5.75
<u>24 lbs. - 26 lbs. 15 ozs.</u>		5.4	5.65
<u>27 lbs. - and over</u>		5.3	5.55

3. With respect to ready-to-cook chicken carcasses which are to be cut-up, averaging $4\frac{1}{2}$ pounds or less that are chilled in continuous chillers and further aged or chilled in slush ice and water, the maximum amount of moisture absorption and retention shall not exceed (when placed on the cut-up line) the percentage limits set forth in the following table: -*



*-

Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)

Zone A -- Product shall be retained if more than one test exceeds	10.0
--	------

Zone B -- Product shall be retained if any test exceeds	11.0
---	------

4. With respect to ready-to-cook chicken carcasses which are to be cut-up, averaging $4\frac{1}{2}$ pounds or less that are chilled in continuous chillers only, the percentage limits set forth in Part 5 of this Section shall apply.

5. With respect to ready-to-cook poultry that is to be ice packed, the maximum amount of moisture absorption shall not exceed, at the last readily accessible point at which the poultry carcasses can be selected for testing on the drip line, the percentage limits set forth in the following table:

Maximum limits for ice pack poultry.

Average percent increase in weight over weight of carcass prior to final washer (less necks and giblets)

Zone A -- Product shall be retained if more than one test exceeds	12.0
--	------

Zone B -- Product shall be retained if any test exceeds	13.0
---	------

6. With respect to all ice pack poultry, the loss of moisture during holding and transportation to the first destination shall result in moisture retention that is within the limits, applicable to the class of poultry involved, set forth in Zone A of Tables 1 and 2 in Part D(1) of this section. For the purpose of moisture control only, holding and transportation to the first destination means not to exceed a 24-hour period. -*

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*- 7. Example of Noncompliance Using Control Tables.

The following examples of ice pack chickens will apply to all other classes of poultry by substituting the class and limit allowed in accordance with the appropriate control table.

(a) Ice Pack Chickens

Test #1	Test #2	Test #3	Test #4	Test #5
12%	10.5	10.5	12.7	10.5

Poultry would be allowed to move freely. Start new series of five tests.

(b) Ice Pack Chickens

Test #1	Test #2	Test #3	Test #4	Test #5
12%	12.5	12.2	10.5	10.5

Poultry would be retained between test #3 and test #4 in accordance with Part A and Part E. Start new series of five tests.

(c) Ice Pack Chickens

Test #1	Test #2	Test #3	Test #4	Test #5
12%	13.1	10.5	10.5	12.5

Poultry would be retained between test #1 and test #2 and again between test #4 and test #5 in accordance with Part A and Part E. Start new series of five tests.

(d) Ice Pack Chickens

Test #1	Test #2	Test #3	Test #4	Test #5
12%	10.5	10.5	12.5	12.5

Poultry would be retained between test #5 and test #6 in accordance with Part A and Part E; provided that #6 is in compliance with the tolerances set forth in Zone A of the appropriate table in Part D(1) of this section. If test #6 were above these limits, poultry would continue to be retained until a test showing compliance is attained. Once a test showing compliance with the limits set forth in Zone A of the appropriate table is attained, the control table is to be used to determine compliance by beginning a new series of five tests. -*

*-E. Procedure For Retained Product. Retained poultry can be released only after sufficient tests have been conducted to determine compliance. These tests must be conducted under the direct supervision of the inspector. In all cases, "U.S. Retain" tags must be used to identify such product.

The plant must select a random sample of at least 50 birds immediately after obtaining the results of a test over the allowed limit. The 50-bird sample must be selected from a point as near as possible to where the final weighing was conducted (end of drip line, point of packaging, etc.). If all poultry has been packed before the computations are completed, the sample birds may be selected from containers at random. The 50-bird sample must be weighed in bulk form, or individually, before drainage begins. Should a subsequent test show moisture absorption to be above the limit, another sample of 50 birds must be selected to establish the required drain time. In all cases, the percentage of moisture above the limit set forth in Zone A, Table 1 or 2 in Part D(1) of this section whichever is applicable to the class of poultry tested must be lost before poultry can be released (see the example for computing moisture loss). If this method is used, all poultry retained must follow the same procedure as the sample birds.

Example for Computing Moisture Loss: Tests on frying chickens that were allowed 12 percent for ice packing showed the actual moisture absorbed to be 13.25 percent. Since the frozen limit set forth in Zone A, Table 1 of this section is 8 percent, the 50-bird sample must lose 5.25 percent. The 50-bird sample selected at random at the end of drip line weighed 1,936.00 total ounces.

To arrive at the estimated original weight, add 100 percent to actual moisture gain of 10-bird test:

$$\begin{array}{r} 100.00 \\ + 13.25 \quad \text{moisture gain of 10-bird test} \\ \hline 113.25 \end{array}$$

Divide this into total weight (ounces of 50-bird retained sample):

$$\frac{1709 \text{ ounces - estimated original}}{113.25 / 1936.0000 \text{ weight}}$$

Multiply the estimated original weight (1709) by percent allowed (8) to arrive at number of ounces allowed:

$$\begin{array}{r} 1709 \text{ estimated original weight} \\ \times .08 \text{ percent allowed} \\ \hline 136.72 \text{ allowed ounces gain} \end{array}$$

The allowed ounces (136.72) added to the estimated original weight (1709) is the number of ounces that the sample must shrink to before retained product can be released:

$$\begin{array}{r} 136.72 \text{ allowed ounces gain} \\ + 1709.00 \text{ estimated original weight} \\ \hline 1845.72 \text{ for compliance -*} \end{array}$$

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*-As an alternative, prior to shipment, ice pack poultry may be held in continuously drained containers for not less than 24 hours.

Approved ice pack containers, tanks with drain plugs open, or other acceptable containers may be used to hold retained product. In all cases, retained product must be maintained at temperatures not to exceed 40° F. This poultry must remain in a fresh state in order to allow sufficient drainage.

If poultry has been packed and allowed to drain while still in the container, particular care must be taken by the establishment and inspectors to insure the correct new weight before the product leaves the official plant.

When product is retained, all pertinent information must be documented in the remarks section of Form CP-549.

F. Moisture Controller's Responsibilities.

1. Moisture Controllers shall act as technical representatives of the Regional Director on all matters pertaining to chilling, temperature requirements and moisture control.

2. Conduct extensive tests to verify the procedure or procedures established by plant management.

3. Retain product during the period of testing if tests show noncompliance.

4. Train and supervise field inspection personnel in moisture control and chilling requirements.

5. Audit in-plant moisture control files to assure proper tests and acceptable records.

6. Furnish the Regional and national offices detailed reports as to the efficacy of the moisture control program in each plant.

7. Furnish data as needed when changes are made in processing operations that affect moisture control.

8. Approve reduced sampling plan in plants where conditions warrant less testing.-*

Example CP-549

DAILY MOISTURE RECORD									REGION			NAME OF PLANT			PLANT NO.																	
									Northern			John Doe Poultry Company			47																	
NOTE: See Instruction on reverse.									SCALE GRADUATION			MONTH AND YEAR			SIGNATURE OF INSPECTOR																	
									1/10 ounce			February 1970																				
PART 1 - INDIVIDUAL BIRD MOISTURE ABSORPTION TEST FOR ICE PACK, FROZEN OR CUT - UP POULTRY																																
TEST 1	WEIGHT						TEST 2	WEIGHT						TEST 3	WEIGHT																	
BIRD NO.	BEFORE WASHING			ICE PACK			FROZEN OR CUT-UP 1/			BIRD NO.	BEFORE WASHING			ICE PACK			FROZEN OR CUT-UP 1/			BIRD NO.	BEFORE WASHING			ICE PACK			FROZEN OR CUT-UP 1/					
	LB.	OZ.	FR.	LB.	OZ.	FR.	LB.	OZ.	FR.		LB.	OZ.	FR.	LB.	OZ.	FR.	LB.	OZ.	FR.		LB.	OZ.	FR.	LB.	OZ.	FR.						
1										1	2	2	8	2	6	4	2	5	9	1	2	8	0	2	13	4						
2										2	2	4	6	2	8	5	2	7	6	2	2	4	3	2	9	6						
3										3	2	1	8	2	5	2	2	4	0	3	2	8	4	2	14	9						
4	NO OPERATIONS										4	2	10	5	2	13	4	2	12	9	4	2	8	3	2	14	0	NONE				
5										5	1	14	5	2	2	9	2	2	1	5	2	11	6	2	15	8	FROZEN					
6										6	1	11	1	1	13	1	1	12	6	6	2	7	0	2	12	4						
7										7	2	11	0	2	14	8	2	13	6	7	2	6	9	2	11	8						
8										8	2	11	8	2	15	3	2	14	1	8	2	5	0	2	10	1						
9										9	1	14	0	2	2	1	2	1	5	9	2	6	5	2	11	3						
10										10	2	13	3	2	15	9	2	14	8	10	1	14	2	2	3	6						
TOTAL OZ.											TOTAL OZ.	367.4			401.6			393.1			TOTAL OZ.	384.2			436.9							
DATE	2/10/70			% %						DATE	2/11/70			9.31 %			6.99 %			DATE	2/12/70			13.71 %			%					
CLASS 2/							DRAIN TIME IN TANKS				CLASS 2/	young chickens						DRAIN TIME IN TANKS				CLASS 2/	young chickens						DRAIN TIME IN TANKS			
TIME IN CHILLER							MIN.	HR./MIN.			TIME IN CHILLER	38 MIN.						1 HR./MIN.				TIME IN CHILLER	39 MIN.						NAHR./MIN.			
CHILL TIME IN TANKS	HR./MIN.			TIME ON DRIP LINE			MIN.			CHILL TIME IN TANKS	NA			HR./MIN.			4½ MIN.			CHILL TIME IN TANKS	NA			TIME ON DRIP LINE			4½ MIN.					
OPEN THIGH AND TAIL AREAS							%				OPEN THIGH AND TAIL AREAS							10 %				OPEN THIGH AND TAIL AREAS							20 %			
TEST 4	WEIGHT						TEST 5	WEIGHT						REMARKS:																		
BIRD NO.	BEFORE WASHING			ICE PACK			FROZEN OR CUT-UP 1/			BIRD NO.	BEFORE WASHING			ICE PACK			FROZEN OR CUT-UP 1/			BIRD NO.	BEFORE WASHING			ICE PACK			FROZEN OR CUT-UP 1/					
	LB.	OZ.	FR.	LB.	OZ.	FR.	LB.	OZ.	FR.		LB.	OZ.	FR.	LB.	OZ.	FR.	LB.	OZ.	FR.		LB.	OZ.	FR.	LB.	OZ.	FR.						
1	1	14	6	2	1	4				1	8	5							9	1												
2	2	2	2	2	5	9				2	8	3							8	13												
3	2	12	0	3	0	5				3	7	7							7	14												
4	2	9	6	2	13	1	NONE			4	7	10		NO					8	4												
5	2	3	1	2	6	6	FROZEN			5	8	9		ICE					9	6												
6	1	13	0	1	15	9				6	7	6		PACK					7	13												
7	2	1	8	2	5	2				7	7	10							7	15												
8	1	10	3	1	13	0				8	7	5							7	14												
9	2	6	9	2	10	3				9	7	3							7	8												
10	2	0	1	2	3	7				10	8	1							8	8												
TOTAL OZ.							345.6	379.6			TOTAL OZ.	1243						1328														
DATE	2/12/70			9.84 %			%			DATE	2/13/70			%			6.83 %															
CLASS 2/	young chickens						DRAIN TIME IN TANKS				CLASS 2/	turkeys						ORAIN TIME IN TANKS														
TIME IN CHILLER							32 MIN.	NAHR./MIN.			TIME IN CHILLER	33 MIN.						2 HR./MIN.														
CHILL TIME IN TANKS	NA			TIME ON DRIP LINE			4½ MIN.			CHILL TIME IN TANKS	20			HR./MIN.			9 MIN.															
OPEN THIGH AND TAIL AREAS							10 %				OPEN THIGH AND TAIL AREAS	BAR CUT						%														

1/ Circle "cut-up" if cut-up poultry.
 2/ Turkeys: Specify test numbers and allowed tolerance in remarks space.

PART 2 - MOISTURE ABSORPTION - BULK WEIGHT TEST

NOTE: See Instructions Below

DAY OF MONTH (1)	WEIGHT (2)						NAME OF PLANT MONTH AND YEAR	PLANT NO.			
		BOX 1 (Lb.) (3)	BOX 2 (Lb.) (4)	BOX 3 (Lb.) (5)	BOX 4 (Lb.) (6)	BOX 5 (Lb.) (7)		OIFF. IN WEIGHT (Lb.) (9)	NO. OF BOXES (10)	AVERAGE OIFF. IN BOX (Lb.) (11)	TARE WEIGHT (Lb.) (12)
Marked Weight							+		+		=
Actual Weight (After holding)							-		-		=
Marked Weight							+		+		=
Actual Weight (After holding)							-		-		=
Marked Weight							+		+		=
Actual Weight (After holding)							-		-		=
Marked Weight							+		+		=
Actual Weight (After holding)							-		-		=
Marked Weight							+		+		=
Actual Weight (After holding)							-		-		=

INSTRUCTIONS

Inspectors in charge of plants which ice pack poultry and which use continuous chillers must, unless otherwise notified, conduct these tests daily. Complete the form in duplicate, forward the original to the area office weekly, and retain the copy. Inspectors in plants using standard chill tanks (and other inspectors who are notified by area supervisors), shall conduct tests weekly and forward the original report to the area office weekly.

If no test is conducted, give the reason in the space where the daily test would normally be recorded.

Use the Individual Bird Test if scales are available.

Completing Part 1 - Individual Bird Test

1. Weigh birds to the nearest fraction of an ounce. Exclude the weight of the neck and giblets in all weighings.
2. Compute totals for each column and record average percentage gained after washing, chilling, and draining.
3. In lower portion of each test, record the data, etc., as shown.

Completing Part 2 - Bulk Weight Tests

1. In column 1 record the day of the month the poultry was packed.
2. Each day select at random 5 boxes of poultry which have been held in ice-packed form for approximately 24 hours; record the marked weight of each box in columns 3 to 7, inclusive. Do not select undergrades.
3. Remove the birds from the boxes and shake off any ice

which may be on the poultry; bulk weigh the contents of each box; and record the actual weights in columns 3 to 7, inclusive.

4. Total the marked weights (columns 3 - 7) and record in column 8.
5. Total the actual weights (columns 3 - 7) and record in column 8.
6. If the total actual weight is more than the total marked weight, record the difference in the plus (+) section of column 9; if the total actual weight is less than the total marked weight, record in the minus (-) section of column 9. If the weights are the same, show "0" in the space between the plus and minus sections.
7. In column 10 record the number of boxes tested.
8. Divide the difference in total weight by the number of boxes tested, and record the result in column 11.
9. In column 12 record the tare weight that is allowed for webpage that occurs on product that is to be delivered the day after processing.
10. If the actual weight is greater than the marked weight, deduct the average difference per box from the tare weight and record the adjusted tare weight in column 13. If the actual weight is less than the marked weight, add the average difference per box to the tare weight and record the adjusted tare weight in column 13. If the actual weight is the same as the marked weight, there will be no need for adjustment; therefore, the adjusted tare weight will be the same as the tare weight.

REMARKS

Chilling of R.T.C. Parts

Partial trimming and part salvage often result in parts of major size (front or back portions) wherein the greater portion of the carcass remains intact. These portions may be chilled in a continuous chiller, refrigerated water, or slush ice water.

Individual parts, from salvage procedures such as drumsticks, thighs, split carcasses, split breast, split backs, etc., may be cooled in air or in ice or water spray with continuous drainage except when prepackaged and placed immediately into a freezer. Cooling procedures shall be such as will minimize moisture absorption and retention.

Section 81.50(d) COOLING GIBLETS

Giblet wrappers or bags shall be so constructed as to facilitate adequate drainage. Wrappers shall be applied closely and tightly around the giblets.

The basis weight, size and moisture absorption requirements are specified in § 81.50(d). The laboratory shall examine specimens obtained from processing plants through a systematic sampling. When such requests are made, inspectors shall submit a sample of 20 sheets which are representative of the shipment or lot. If the plant uses more than one size or type of paper, 20 sheets of each type shall be submitted.

The inspector may determine compliance with the size requirements specified in the regulations by measuring uncrimped sheets. The size of crimped sheets, and the basis weight and moisture absorption of any questioned lot of paper may be obtained from the laboratory by submitting samples (20 sheets per sample) with a Form PY-112.

*-A. Vermin Harbors

1. Elimination and destruction of insects and rodents in and around meat packing plants are vital to good sanitation. Two principles should be followed: Prevent their breeding; and prevent their entrance into establishments. In nearly all cases the owners of adjoining properties and the local health authorities will cooperate in developing a program for insect and rodent control. The management should obtain such cooperation. Any place that will afford food, water, and a hiding place is a potential source of pests. The most common places are manure piles, trash piles and garbage dumps. Regulations do not permit such accumulations on the premises of official establishments. The cooperation of the local health authorities should be solicited by the management in eliminating such breeding places from the vicinity of meat packing plants.
2. Buildings and equipment that harbor pests should be repaired or replaced so as to eliminate breeding and hiding places. Walls, floors, and ceilings that have been tunneled by rodents should be replaced with rodent-proof material, such as concrete or brick. Tunnels may be blocked with 17-gauge hardware cloth, glass, metal, or other rodent-proof material. Stone and brick walls shall have the joints pointed up flush and smooth, and all cracks, crevices, and openings around pipes, etc., shall be sealed tight. Walls, ceilings, and partitions shall be of tight-fitting material that will not permit the entrance or hiding of cockroaches and other pests. Floor drain strainers should be in good repair and should remain in place so as to prevent the entrance of rats through drainage lines. Dressing rooms and lunch rooms shall be so equipped and maintained as to eliminate any breeding or hiding places.
 - a. Lockers should be examined regularly by the management and inspectors to see that they are kept clean and free from pests. Overcrowding (more than one person to a locker) should not be permitted since it is difficult to keep overcrowded lockers clean and free from cockroaches.
 - b. Lockers are not required in establishment welfare facilities if alternate means of storing work clothing and equipment are provided that keep employees' clothes in an orderly and sanitary manner.
 - c. Establishment welfare rooms must be kept neat and clean whether or not lockers are provided.
 - d. Alternate means of storing work clothing and equipment will be considered if this can be accomplished in an orderly and sanitary manner.-*

Labels for containers for bulk ice-packed poultry and outside containers for institutional packs and consumer packages will continue to be forwarded by plant management to the Poultry Labels and Packaging Group, Labels, Standards and Packaging Branch, for approval. Entire boxes or panels are not to be forwarded; instead, stripped panels, paper take-offs or photostats will expedite handling.

In case of doubt concerning any label offered by plant management for approval, the inspector-in-charge may forward the label in question to the Poultry Labels and Packaging Group, Labels, Standards, and Packaging Branch for comment and advice.

Section 81.139 of the regulations provides some variations in labels.

Labeling of Rock Cornish Game Hen and Cornish Game Hen

The following guidelines are to be followed as a means of assuring proper labeling of Rock Cornish Game Hens and Cornish Game Hens:

1. Perform adequate ante-mortem inspection. Determine whether the lot of chickens about to be slaughtered is only five or six weeks old immature chickens. Leghorns or Mediterranean breed type crosses shall not be labeled as "Rock Cornish Game Hen" or "Cornish Game Hen." White ear lobes would indicate that the birds are Leghorns or the Mediterranean type.
- *-2. Lots which are processed as "Rock Cornish Game Hen" or "Cornish Game Hen" shall be slaughtered separately from other lots. Be sure that carcasses, necks, and giblets are kept separate from like items of other broiler lots, and packaged separately. This will prevent oversized necks and giblets from being included with "Rock Cornish Game Hen" or "Cornish Game Hen" packs. If the neck and/or giblets are not included, the term "Without Neck and Giblets," "Without Giblets," or "Without Neck" shall appear directly below the product name on the label. The net weight of the packaged product shall not exceed 2 lbs., with or without the neck and giblets. When stuffed, the product may weigh in excess of 2 lbs. by the weight of the stuffing".-*
3. The subject class names shall not be used on under-weight frying chickens which remain or have been removed from a straight run flock of commercial broilers. The result of this should be that all poultry packed under this class name was either grown for this particular purpose or was selected from a growing flock slaughtered before it reached maturity.
4. Supervise packaging and labeling sufficiently close to assure compliance with the regulations under the guidelines for procedures.

5. Ready-to-cook product received at an official plant for further processing and ultimate repackaging and relabeling as "Rock Cornish Game Hen" or "Cornish Game Hen" must be similarly labeled upon receipt since the inspector would have no other prior knowledge upon which to make the above determinations.

The use of the word "Cornish" in conjunction with other class names (Cornish Roaster, Cornish Young Chicken, etc.) is applicable only when the product is prepared from a pure-blooded Cornish chicken.

-The use of the wording "Rock Cornish" in conjunction with other class names (Rock Cornish Roaster, Rock Cornish Hen) is applicable only when the product packed is a cross of a Rock breed chicken and a Cornish breed chicken.--

Supervision of Labeling and Formula Compliance

- A. Labels bearing the official inspection mark shall not be used prior to approval in accordance with Sections 81.125 through 81.146 of the regulations and the following policies:

Any formula will be approved for use only in conjunction with its specific label. The product formula accompanying approved labels is the guide telling the inspector whether the various ingredients used are the ones called for on the label and whether or not the proper amount of each ingredient is being used and is present in each container of the product named on the approved label.

- B. It is the responsibility of each inspector to make the necessary inspection of processing and/or freezing procedures to assure himself that the approved formula, the net weight statement, processing, and freezing procedures are being adhered to in the packing of any product that is to bear the official inspection mark as well as that nonpoultry ingredients are wholesome. Complete label files must be kept under lock and key for all products being currently packed so that only authorized inspection personnel have access to the confidential information dealing with approved labels and formulas.

Inspector's file copy of labels which have been given temporary approval shall be destroyed 30 days after the date of termination of the temporary approval, except that when the terminated label has a formulation attached to it, the complete label (with any formulation and method of preparation) shall be returned to a responsible member of management for destruction or other disposition. File copies of labels having been terminated for other reasons shall be destroyed in a like manner.